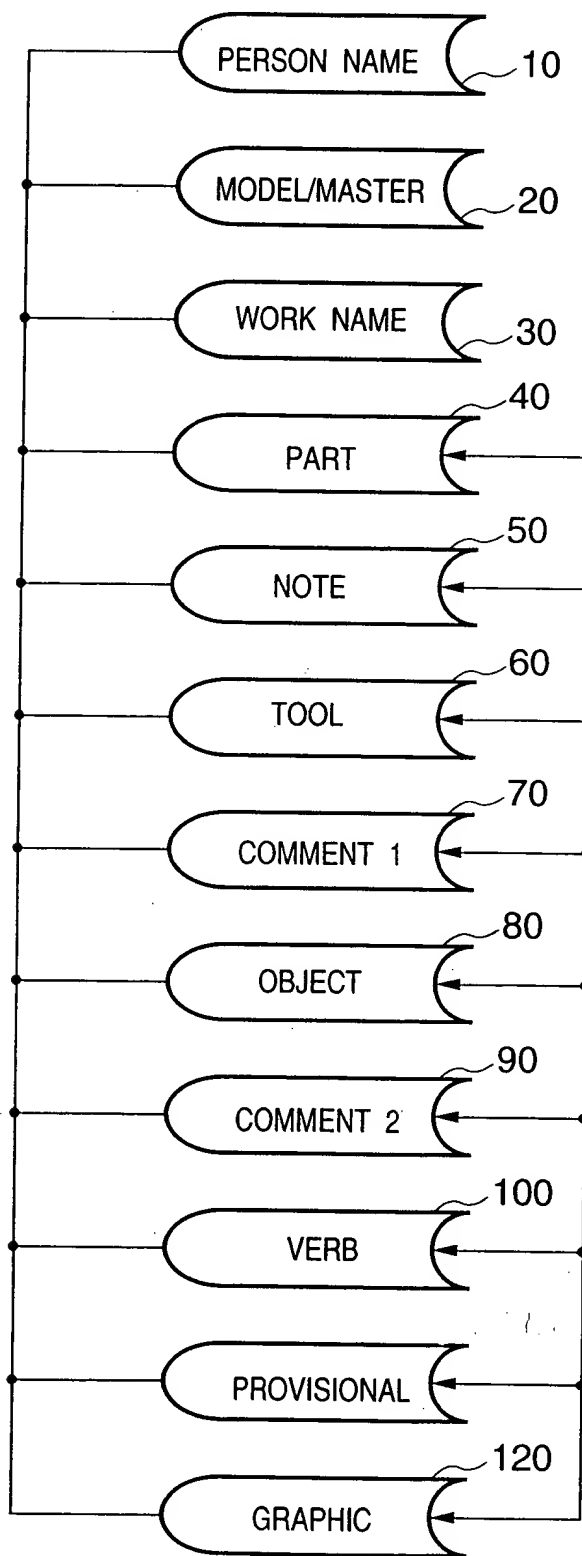


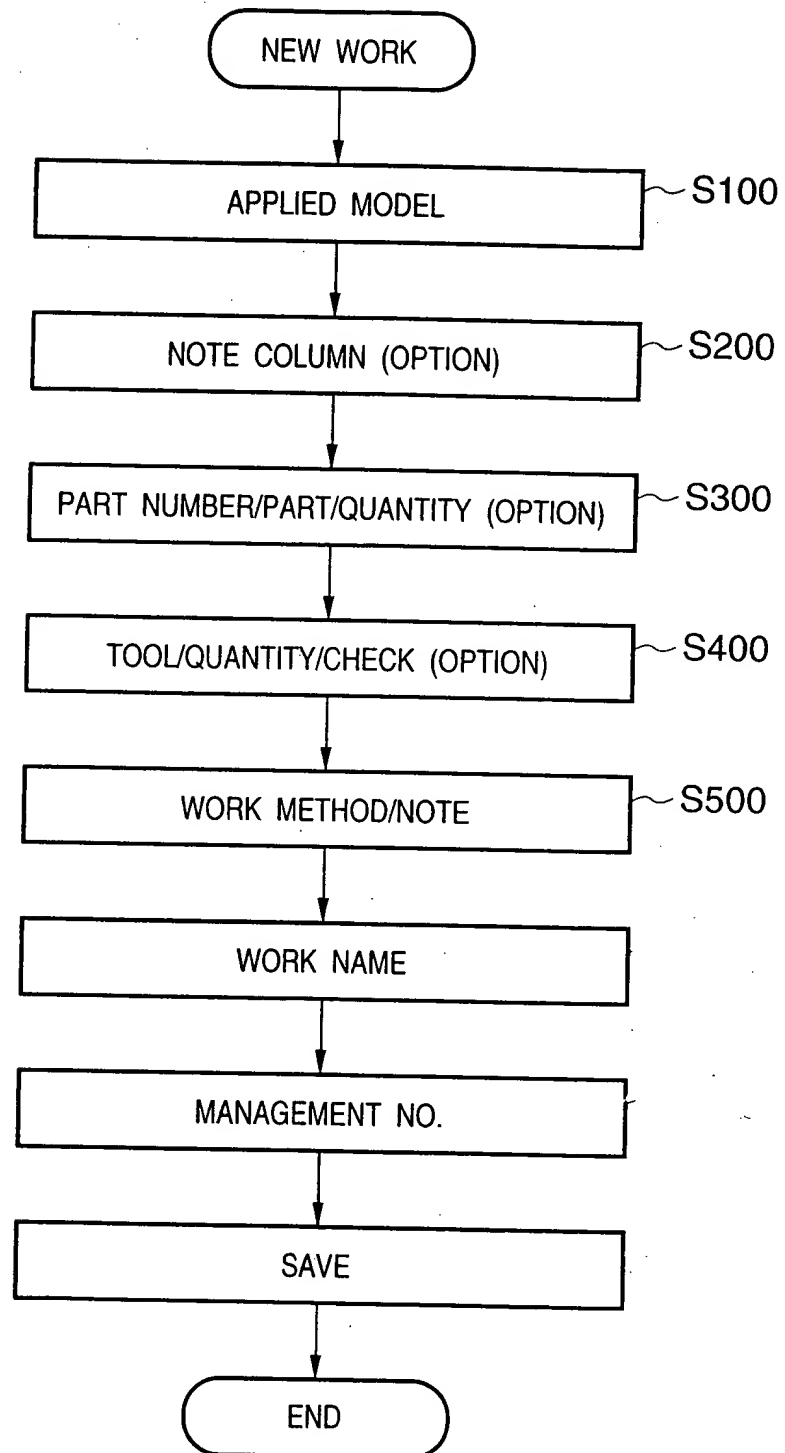
# FIG. 4

## STRUCTURE OF MASTER FILE



REPLACEMENT SHEET  
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**FIG. 5**



## REPLACEMENT SHEET

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FIG. 23

WORK STANDARD SYSTEM			
<input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL			
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	SET ASFu	1997/09/13
SO-01-01(3)-E	01	SET BASE TRAY	1997/09/01
SO-01-03-E	01	SET BASE TRAY	1997/09/01
SO-01-04-E	01	SET BASE TRAY	1997/09/01
SO-06-01-E	01	WIRING	1997/09/01
SO-06-02-E	01	WIRING	1997/09/01
SO-06-03-E	01	WIRING	1997/09/01
SO-07-01(2)-E	01	GREASING	1997/09/01
SO-08-01-E	01	SET RAIL	1997/09/01

2301

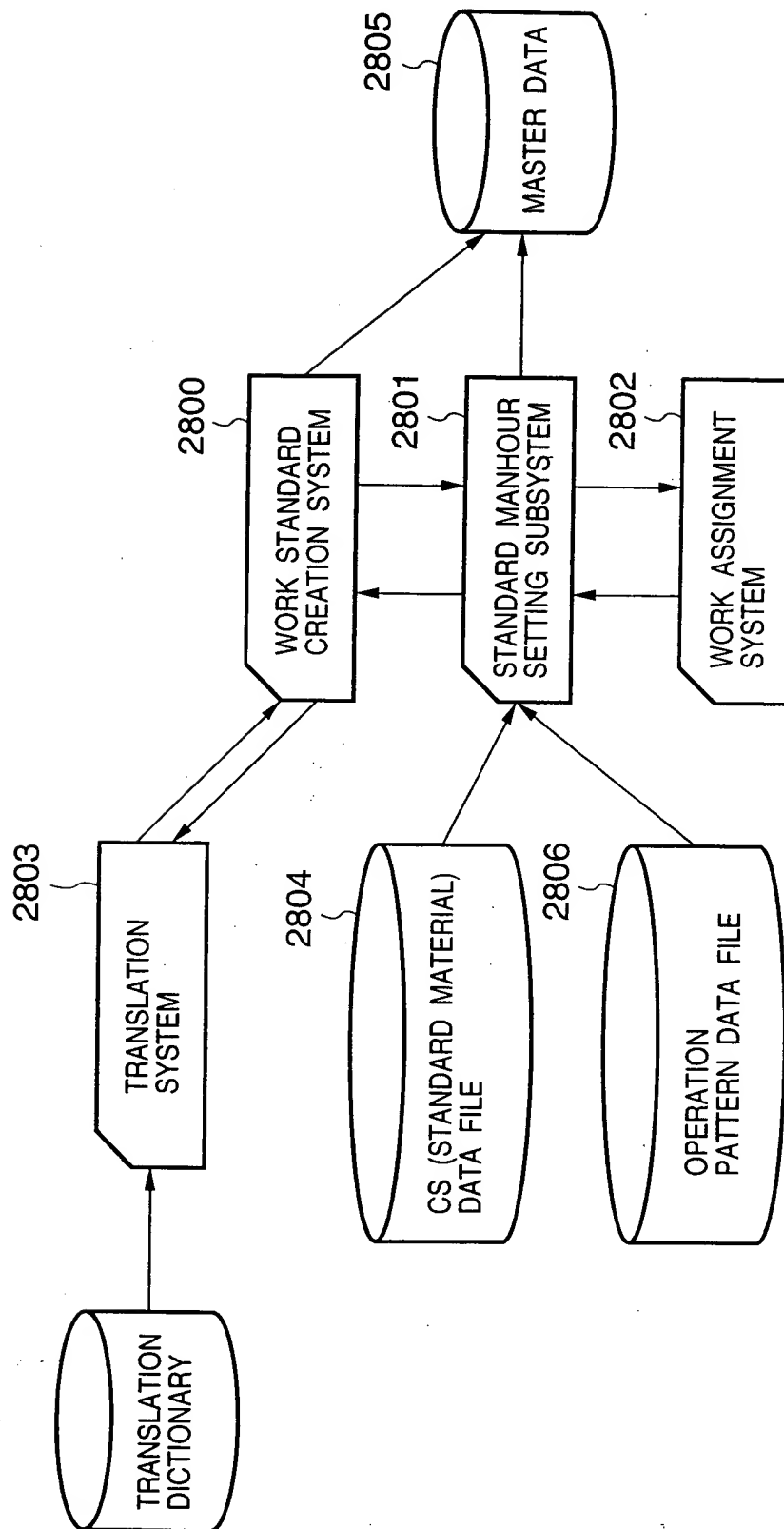
**FIG. 25**

WORK STANDARD 01 CREATION				
<div>APPLIED</div>				
PART NUMBER	PART NAME			
303				
TOOL / TREATMENT DEVICE				
No.	WORK PROCEDURE			
	FILE NAME : 2501			
REVISION NUMBER		CONTENTS OF REVISION	DATE	PERSON IN CHARGE
01	CREATED	1997/09/25		
WORK NAME		MANAGEMENT NO.		

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FIG. 28



## REPLACEMENT SHEET

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FIG. 30

3001 3002 3003 3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL  
☒ UNIT  
☐ ASSEMBLY

☒ ALL  
☐ UNTRANSLATED  
☐ UNCHECKED

☐ JAPANESE  
☒ ENGLISH

3000

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION CHECK	
PT - 010 - 010	01	SET CLEANER UP	X	X
PT - 010 - 020	01	SET CLEANER UP	X	X
PT - 010 - 030	01	SET CLEANER UP	X	X
PT - 070 - 030	01	ASSEMBLE CHANGEOVER ARM	X	X
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 100 - 010	01	SET SHEET HOLDER	X	X

3006 3007 3008 3005

**FIG. 31**

<b>TRANSLATION OF WORK STANDARD (PROTOTYPE)</b>									
<b>WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W)</b>									
<b>WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT</b>									
<b>Model</b>	QG5-1319								
<b>Part No.</b>	<b>Part Name</b>	<b>Qty</b>	<b>Part No.</b>	<b>Part Name</b>	<b>Qty</b>	<b>Part No.</b>	<b>Part Name</b>	<b>Qty</b>	<b>Part No.</b>
<b>Total</b>					<b>Qty</b>	<b>PN</b>			
<b>No.</b>	<b>Procedure</b>				<b>No.</b>	<b>Precaution / Conditions</b>			
01	The blade lever spring hooks to ① of the blade lever.								
02	Side the blade lever in the direction of arrow ② and check there is no catch and nor the return by the spring force.				02 - 01	No Table Data 1			
03	Check press-fitting the blade lever shaft leading edge to the braid folder leading edge.				03 - 01	No Table Data 1			
	<b>Details is of Revision</b>	<b>Data</b>	<b>By</b>	<b>OK</b>	<b>Procedure</b>				
01	New Created by (PX2056)				No Table Data 1				
					<b>Page No.</b>				
					PN-030-020				

**FIG. 47**

[illegible]



**FIG. 55**

SELECTION OF MODEL

FILE(E) EDIT(E) VIEW(V)

PRODUCT SYMBOL : BJ - 970909    NAME : 097 - 09 - 09 LOAD SET MODEL SYMBOL : BJC - 4300

COMPONENT SYMBOL : ON    NAME :    NAME : xxxxxx

LATEST REVISION NUMBER

UPDATE DISPLAY

S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY
▶ N <sup>1</sup> 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	1
N <sup>1</sup> 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	1
N <sup>1</sup> 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	1
N <sup>1</sup> 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	1
N <sup>1</sup> 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	1

N <sup>1</sup> 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	1
N <sup>1</sup> 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	1
N <sup>1</sup> 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	1
N <sup>1</sup> 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	1

No. FORMAL MANAGEMENT NO.

	UNIT WORK NAME	MANHOUR	USE	FREQUENCY	1	2	3	4	5
3 CH-01-01	ELECTRICAL CHECK	0	0	0	1				

☐ CHANGE   ☐ INSERT   ☐ ADD

OK

5501

5507

5506

5502

5503

5504

5505

Fig. 56

XXXXXX					
FORMAL MANAGEMENT NO. PU-03-01		UNIT WORK NAME : MOTOR ATTACHMENT		TOTAL MANHOURLY : 0	
				NEXT UNIT WORK	

NO.	ELEMENT WORK NAME	REVISION	MANHOURLY	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						

**COMMENT 1 :** TO OPPOSITE SIDE OF AXIS

**OBJECT :** DOUBLE GEAR

**COMMENT 2 :** IN ORDER OF SMALL GEAR DIAMETER

**VERB :** SET

5604
5605
5603
5602
5601

## REPLACEMENT SHEET

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FIG. 57

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USEFREQ.	COUNT	SET DATE
▶	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N/>6/-3	15	0 1 1	0	97/09/09 9:52
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/E/02/N/-6	11	0 1 1	0	97/09/09 9:53
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N/>6/-3	15	0 1 1	0	97/09/09 9:55
		ELEMENT WORK 01		VERB	-50/G1/N/>6/-3	15	0 1 1	0	97/09/09 16:34
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N/>6/-3	15	0 1 1	0	97/09/09 19:09
		CARRIAGE LOCK		APPLY	Time100/Rate100	100	100 1 1	1	97/09/09 19:16
	ASSEMBLE MOTOR	PRINTER CHASSIS		INSERT & SET	M211/1/10	50	1 1 1	1	97/09/09 17:00
		PRINTER CHASSIS		TURN INSIDE OUT	T1221/M2311/0/0	12	0 1 1	0	97/09/09 17:34
	1			1	T2221/M1211/0/1	24	0 1 1	0	97/09/09 17:20
	2			2	T1221/M2311/0/0	12	0 1 1	0	97/09/09 17:24
	PRINTER CHASSIS	ASSEMBLE PR GUIDE		SET		15	0 1 1	0	97/09/09 11:24
	dgdfafdfas			fdasfdasfdasfd	*	16	0 1 1	0	97/09/09 12:10
	dsdsffsfdsaf			fdasfdsdffds	T21121/M1111/0/1	13	0 1 1	0	97/09/09 12:10
	dgdfafdfas			fdasfdasfdasfd	*	16	0 1 1	0	97/09/09 13:39
	PRINTER CHASSIS	ASSEMBLE PR GUIDE		SET		15	0 1 1	0	97/09/09 14:00
	PRINTER CHASSIS	ASSEMBLE PR GUIDE		SET		15	0 1 1	0	97/09/09 14:00
	PRINTER UNIT			SET	Time100/Rate100	100	100 1 1	0	97/09/09 14:04

# FIG. 58

OPERATION ANALYSIS						5801	5802	5803	5804		
1 SET MAIN BODY TO PREDETERMINED POSITION						TOTAL SIMO VALUE :	0	TOTAL MANHOUR VALUE:	15	SIMO	NEXT ELEMENT WORK
NO.	CONTENTS OF OPERATION		WF/OS	SET CONDITION	MANHOUR	USE	REMARKS				
▲ 1	XXXXXX		PU	-60/Gt1/N/>6/-3	15	0					
*											

FIG. 62

The figure shows a window titled "INQUIRY OF LOG". Inside the window, there are four input fields and two buttons. The first input field is labeled "VARIATION AMOUNT :" and contains the value "10". The second input field is labeled "USE :" and contains the value "0". The third input field is labeled "REASON CODE :" and contains the value "1". The fourth input field is labeled "CHANGE REASON :" and contains the value "SET" with a dropdown arrow on the right. Below these fields are two buttons: "OK" and "Clear".

Reference numerals point to the following elements:

- 6201: Points to the "INQUIRY OF LOG" title bar.
- 6202: Points to the "VARIATION AMOUNT :" label.
- 6203: Points to the "USE :" label.
- 6204: Points to the "CHANGE REASON :" label.
- 6206: Points to the "Clear" button.

# REPLACEMENT SHEET

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## FIG. 72

FILE(F) EDIT(E)

PLAN 1

COMPOSITION EFFICIENCY  %

FILE(F) EDIT(E)

PLAN 1

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

DRAG AND DROP

OK

CANCEL

# REPLACEMENT SHEET

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## FIG. 73

FILE(F) EDIT(E)

PLAN 2

COMPOSITION EFFICIENCY  %

FILE(F) EDIT(E)

PLAN 2

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0008	XXXX	270

St 2

0003	WEIMAN REMOVAL	365
0004	ASSEMBLE OUTER CASE	268
0005	FIT TOP PAD	117

DRAG AND DROP

OK

CANCEL

## REPLACEMENT SHEET

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FIG. 76

7601 7602 7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

f12-0010.csv	TEST DATA (ORIGINAL)	1	97/09/19 12:00:34
f12-0010.csv	TEST	0	97/09/19 13:27:17
BJC-4300	TEST	0	97/09/19 14:10:14
BJC-4300	TEST	0	97/09/19 14:10:32
BJC-4300	TEST	1	97/09/19 15:41:14
BJC-4300	BJC-4300A LINE FORMATION		97/09/20 14:16:58
BJC-4300	BJC-4300A LINE FORMATION	03	97/10/13 17:54:57
BJC-4300	BJC-4300A LINE FORMATION	00	97/09/20 14:06:36
f12-0010.csv	f12-0010A LINE FORMATION	05	97/09/24 17:11:53

SELECT WINDOW

☐ COMPOSITION DATA INPUT WINDOW

☐ COMPOSITOR DATA CORRECTION WINDOW

OK CANCEL



## 77/97

7710b

7710c

7710d

-7720a

7720b

7720c

7720d

## REPLACEMENT SHEET

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FIG. 80

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1 OPERATOR 2 OPERATOR 3 OPERATOR 4 OPERATOR 5

S11 S12 S13 S14 S15

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT NAMEa1	5/9	0	9000
UNIT NAMEa2	54	0	9000
UNIT NAMEa3	10	0	9000
UNIT NAMEa4	50	0	9000

CLEAR(V)

xxxx  
xxxx  
xxxx  
xxxx  
DELETE STATION  
xxxx

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT NAMEu1	63	0	9000
UNIT NAMEu2	30	0	9000
UNIT NAMEu3	156	0	9000
UNIT NAMEu4	35	0	9000

0001 xxx LOCK 201  
0002 MIRROR SPRING 236  
0003 xxx LOCK 285  
0002 MIRROR SPRING 525  
ATTACHMENT

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT NAMEu9	144	0	9000
UNIT NAMEu10	16	0	9000
UNIT NAMEu11	293	0	9000
UNIT NAMEu12	133	0	9000

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT NAMEu13	33	0	9000
UNIT NAMEu14	72	0	9000
UNIT NAMEu15	35	0	9000
UNIT NAMEu16	56	0	9000
UNIT NAMEu17	150	0	9000
UNIT NAMEu18	16	0	9000
UNIT NAMEu19	250	0	9000

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT NAMEu20	250	0	9000
UNIT NAMEu21	0	0	9000
UNIT NAMEu22	50	0	9000
UNIT NAMEu23	55	0	9000
UNIT NAMEu24	88	0	9000
UNIT NAMEu25	147	0	9000
UNIT NAMEu26	52	0	9000
UNIT NAMEu27	55	0	9000

TOTAL 693 (RU) PF 105.0% TOTAL 609 (RU) PF 92.3% TOTAL 566 (RU) PF 86.8% TOTAL 596 (RU) PF 90.3% TOTAL 565 (RU) PF 85.8%

8009 8008 8004 8006

G STANDARD NO. WORK NAME UNIT NAMEa1

MA-CHINE MANHOUR

PROVISIONAL REMARKS

COMPOSITION EFFICIENCY 94.92 %

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE: PRIORITY ORDER SCHEME

8007

tp  
tp\*1.05  
tp\*0.85  
t

900  
720  
540  
360  
180  
0

1 2 3 4 5

REPLACEMENT SHEET

84/97

**FIG. 84**

PARALLEL OPERATION / INTEGRATION OF STATIONS

TARGET STATION : 1

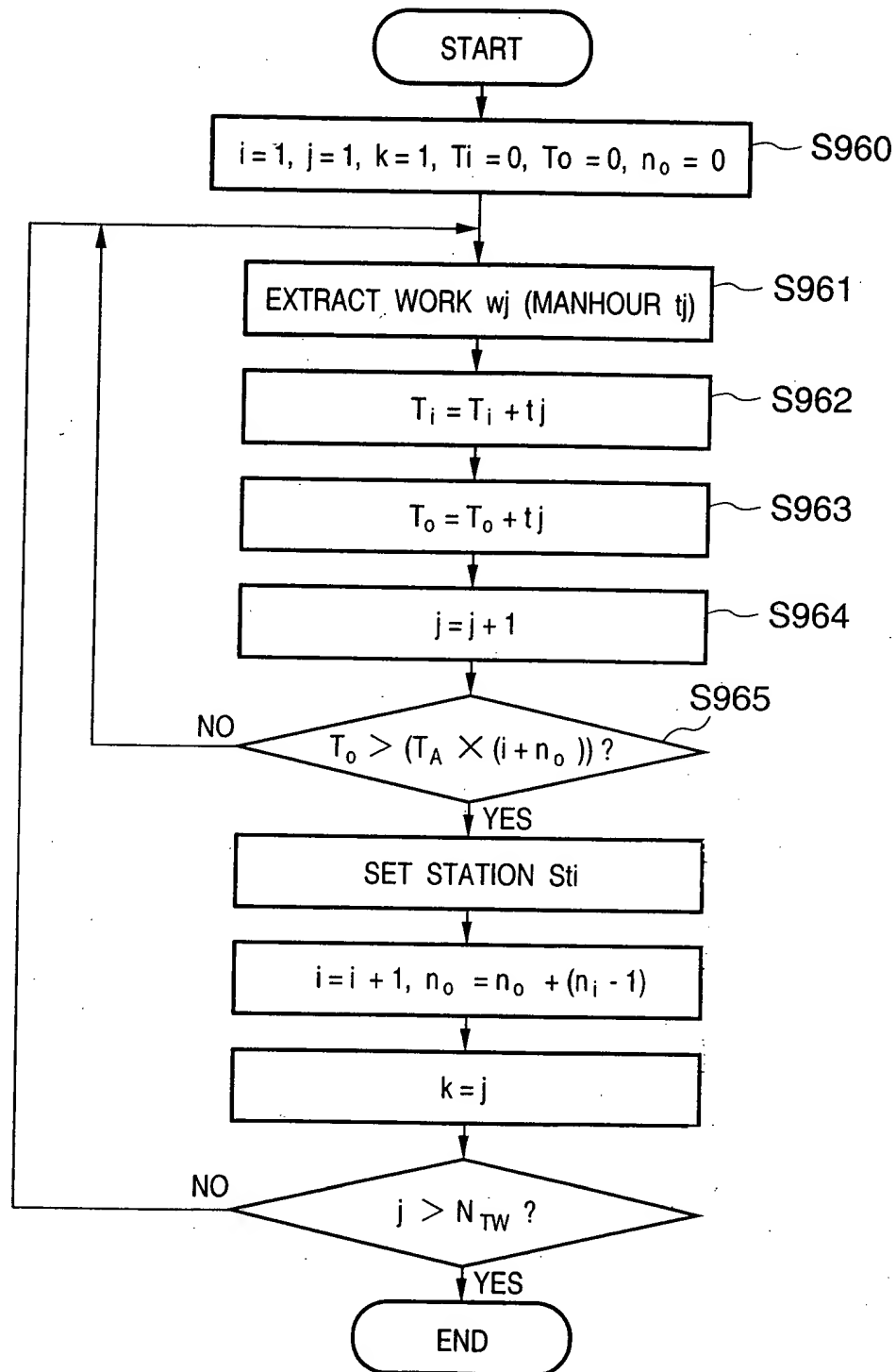
THE NUMBER OF STATIONS  8402

OK CANCEL

## REPLACEMENT SHEET

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## FIG. 96

 $N_{ST}$ : THE NUMBER OF STATIONS $T_i$ :  $i$  STATION MANHOUR $T_A$ : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

 $T_o$ : TOTAL ACCUMULATED MANHOUR $n_i$ :  $i$  STATION PARALLEL NUMBER $n_o$ : TOTAL ACCUMULATED PARALLEL SUM NUMBER

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